

Work Order ID 59349

Wednesday, June 02, 2010 10:32:18 AM



Page 1

Item ID: D3910-1	Accept		Setup	Start	
Revision ID:					
Item Name: Crosstube Lug				Stop	
Start Date: 6/2/2010	Start Qty: 24.00				
Required Date: 6/9/2010	Req'd Qty: 24.00				
Reference:					

Approvals:	Process Plan: <u>MF</u>	Date: <u>10-6-02</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3910	B								

100		0.00							
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK 1.450" LONG								

110		0.00							
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA865 AND DWG								
	FOLIO REV: <u>B</u>								
	DWG REV: <u>B</u>								

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 59349

Page 2

Wednesday, June 02, 2010 10:32:18 AM

Item ID: D3910-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Crosstube Lug
Start Date: 6/2/2010 Start Qty: 24.00  Cust Item ID:
Required Date: 6/9/2010 Req'd Qty: 24.00  Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		H.A 10/06/10		24	Ø		
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		mmf 10/06/10		24	Ø		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				24	Ø		BP 10-6-14

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Page 4

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 6/2/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/17 *[Signature]*
MF
10-6-16

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NOTE: Date, & initial all entries

Picklist Print

Wednesday, June 02, 2010 10:32:17 AM

Page 1

Work Order ID: 59349



Parent Item: D3910-1



Parent Item Name: Crosstube Lug

Start Date: 6/2/2010

Required Date: 6/9/2010

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	470.5321	0.13	3.284211			



Lug Extrusion



Location

Loc Qty

Loc Code

MAT06

470.5320795

43722

180

45800

290.532079

3.2842 ^{ft} L.A 10/06/10

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 59349
Description: X-TUBE LUG (350)		Part Number: D3910-1
Inspection Dwg: D3910 Rev: B		Page 1 of 1

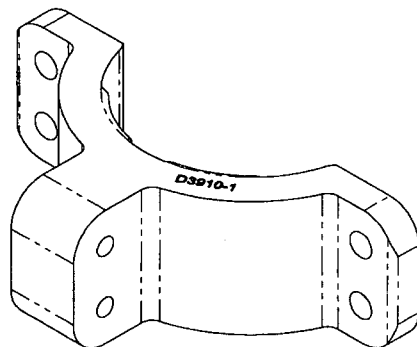
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

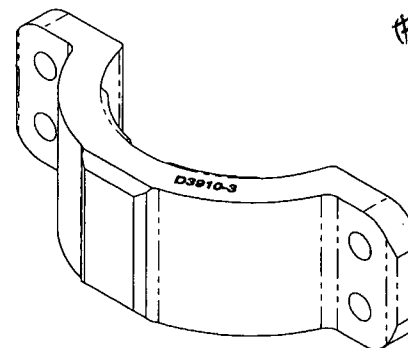
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.38	+/- .030	1.380	✓			
4.45	+/- .030	4.452	✓			
0.27	+/- .030	0.270	✓			REF
0.31	+/- .030	0.309	✓			
R1.20	+/- .030	R1.200	✓			
0.735	+/- .010	0.725	✓			REF
0.375	+/- .010	0.376	✓			
0.625	+/- .010	0.625	✓			
0.375	+/- .010	0.376	✓			
3.700	+/- .010	3.700	✓			
Ø0.257	+0.006/-0.001	Ø0.259	✓			
2.20	+/- .030	2.204	✓			
0.375	+/- .010	0.377	✓			
0.38	+/- .030	0.379	✓			
0.625	+/- .010	0.626	✓			
R0.38	+/- .030	R0.380	✓			
Ø0.191	+0.005/-0.001	Ø0.196	✓			
R0.06-R0.10	0.06 / 0.10	R0.060	✓			

Measured by: J.A	Audited by: [Signature]	Prototype Approval: N/A
Date: 10/06/10	Date: 10/06/10	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3910-1 X-TUBE LUG





D3910-3 X-TUBE LUG

59349

RELEASED
2010-03-22
WP

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-807-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3910	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		X-TUBE LUG (350)	NTS	
DATE	10.03.16	<div><div>COPYRIGHT © 2010 BY DART AEROSPACE LTD</div><div>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</div></div>		

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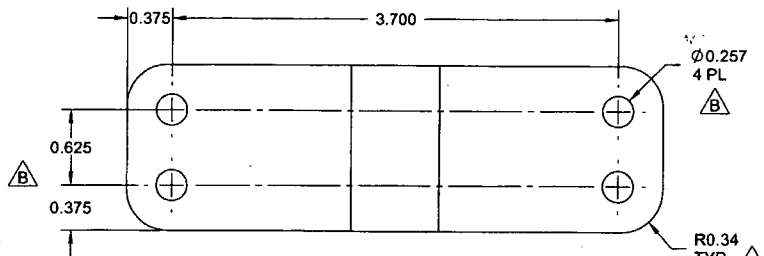
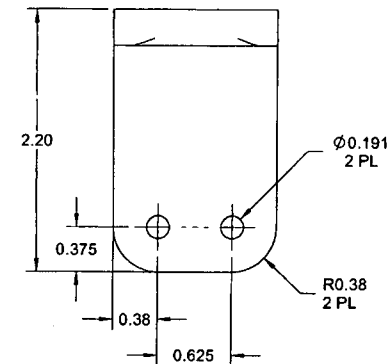
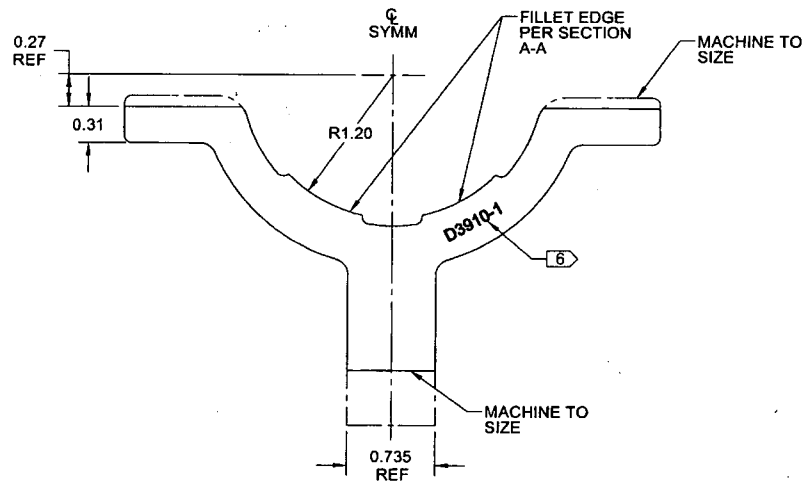
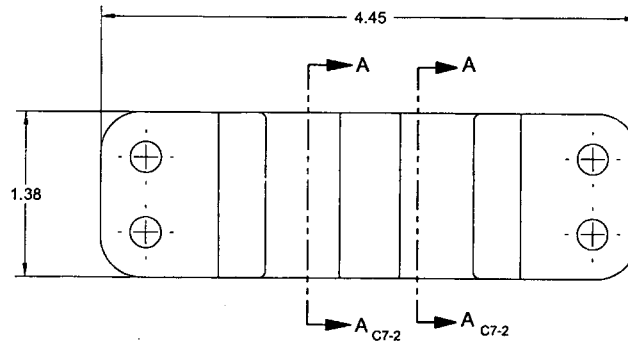
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ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



D3910-1 X-TUBE LUG

#59349

RELEASED
2010-03-22
MD

DESIGN	A/S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D3910	REV. B
MFG. APPR.		TITLE X-TUBE LUG (350)	SHEET 2 OF 3
APPROVED			SCALE
DE APPR.			NTS
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